

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002036**Date Inspected:** 14-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Guogang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Mock-Ups**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring fabrication of the SAS/San Francisco/Oakland Bay Bridge.

77-meter Mock-Up, Z. P. M. C. Personnel rotated and relocated the Mock-Up to continue work on other locations of the Mock-Up.

89-meter Mock-Up—This Mock-Up, has been moved to the new Tower Shop.

Z. P. M. C. Welders, Li Mengqian—054460, Lei Lichao—0531619, and Li Zhaoqian—048810, welded weld number MUB-MA21-D/7-3A, using Welding Procedure Specification (WPS)-B-T-2232-Tc-U5f. The QA Inspector recorded the following parameters at different times: 322 amps, 31.2 volts, and 319 amps, 30.5 volts. Two welders were using one machine, and the third, was using a separate machine. Welder Tan Xiang ho—066459—MUB-MA21-A/J-11, using WPS-B-T-2113, and MUB-MA21-G/J-11. The QA Inspector checked and recorded, the following WPS variables at different times: 162 amps, and 157 amps.

Summary of Conversations:

No pertinent conversations took place.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
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Reviewed By:	Cochran,Jim	QA Reviewer
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